

Date: Friday, 23/05/2008 9:54:55 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG		
Job Number	: 39441		Part Number	: D27313		
Estimate Number	: 11019		Drawing Number	: D2731 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 23/05/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 15/06/2008 Qty: 60 Um: Each		
Previous Run	: 37335					
Written By	:					
Checked & Approved By	: JYL 08.5.23					
Comment	: Est:D 00.05.19 Added inspect level 8, removed P/O for powder coating EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
		Comment: Qty: 0.0717 f(s)/Unit Total: 4.3029 f(s) Lug Extrusion D2423 Batch: 333/0	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut D2423 Extrusion: 0.82" Long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		RG issue R/O: 6434 metec machine pending D2731 R E.O. B Machine as per folio D2731-3 Check for crack while loading into the machine Tumble Deburr any rough edges after tumbling	
4.0	QCS	INSPECT PARTS AS THEY COME OFF MACHINE Received + inspect for tensile damage ensure cut off attached	
		RG 1/8/18 60	
5.0	QCS	SECOND CHECK	
		RG 1/8/18 60	
		Comment: SECOND CHECK Inspect Level 5. 08/06/19 860	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:54:55 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 39441

Part Number: D27313

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



60X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M/L

08/06/19

7.0 POWDER COATING

POWDER COATING



M107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:30pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:00pm

9/1

08-06-19

X60

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



60X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/L 08/06/19

9.0 PACKAGING 1

PACKAGING RESOURCE #1



60X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 461

8/6/26

SO

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/23ff

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M/L 08-06-20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39441
Description: Lug	Part Number:	D2731-3
Inspection Dwg: D2731 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

A hand-drawn diagram on lined paper. It features a circle with a horizontal diameter. A radius line extends from the left endpoint of the diameter to a point on the upper half of the circle's circumference. This point is labeled 'B'. The angle at the center of the circle, subtended by the radius and the arc to point B, is labeled 'alpha'. Above the circle, the letter 'A' is written above the top of the circle. The entire diagram is drawn in black ink.

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF ✓	✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

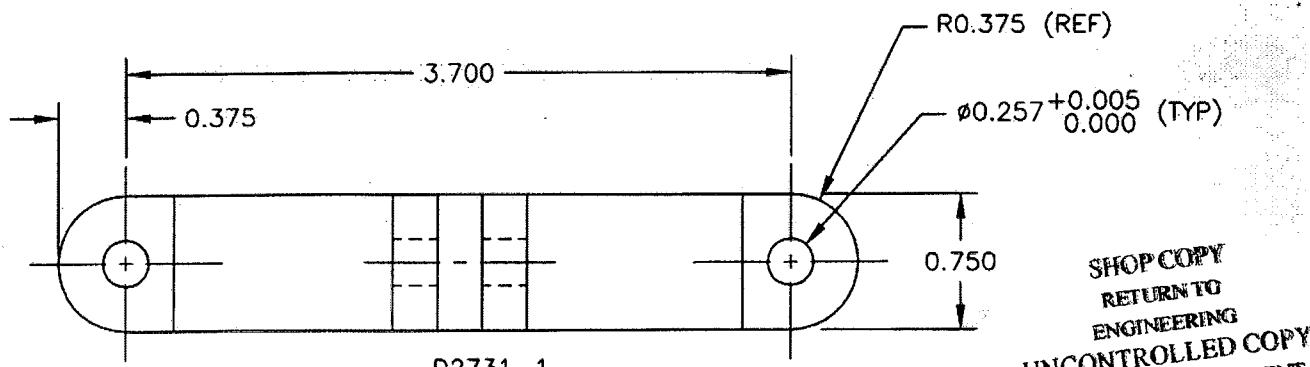
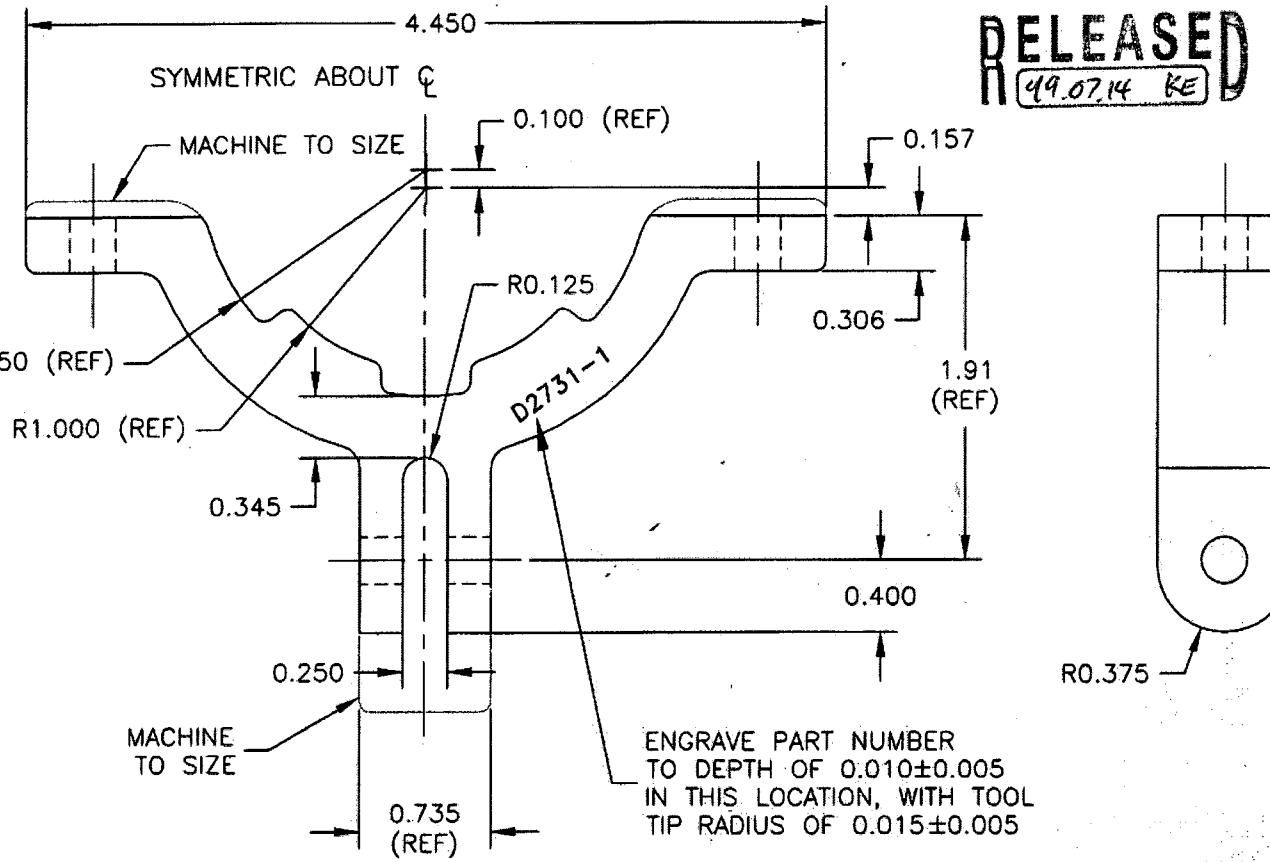
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JX</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 1 OF 4
		TITLE MOUNTING LUG
A	98.05.13	SCALE 1:1
B	99.07.06	REVISED DIMENSIONS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 39441

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

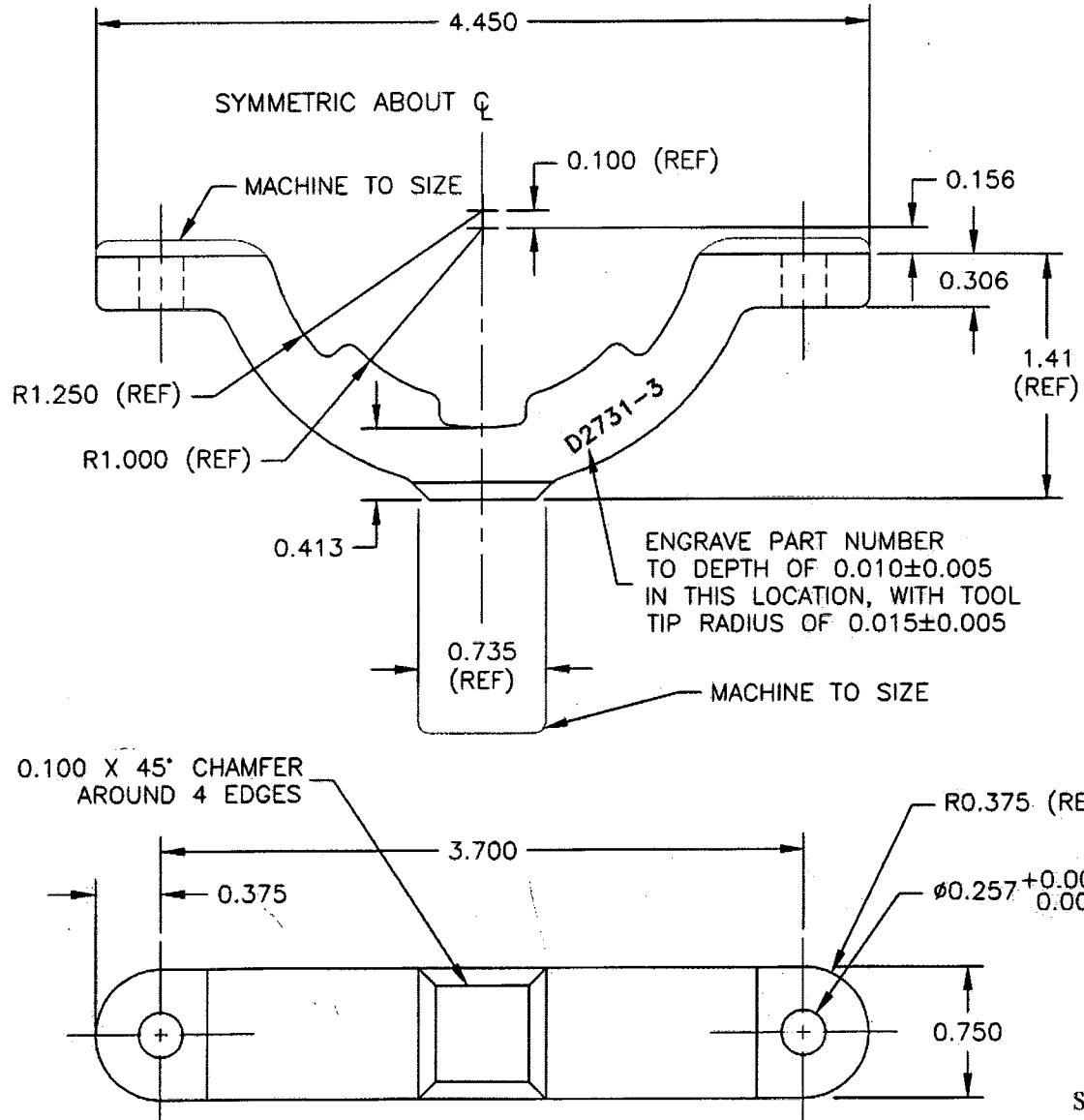
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 2 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
19.07.14 KE

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

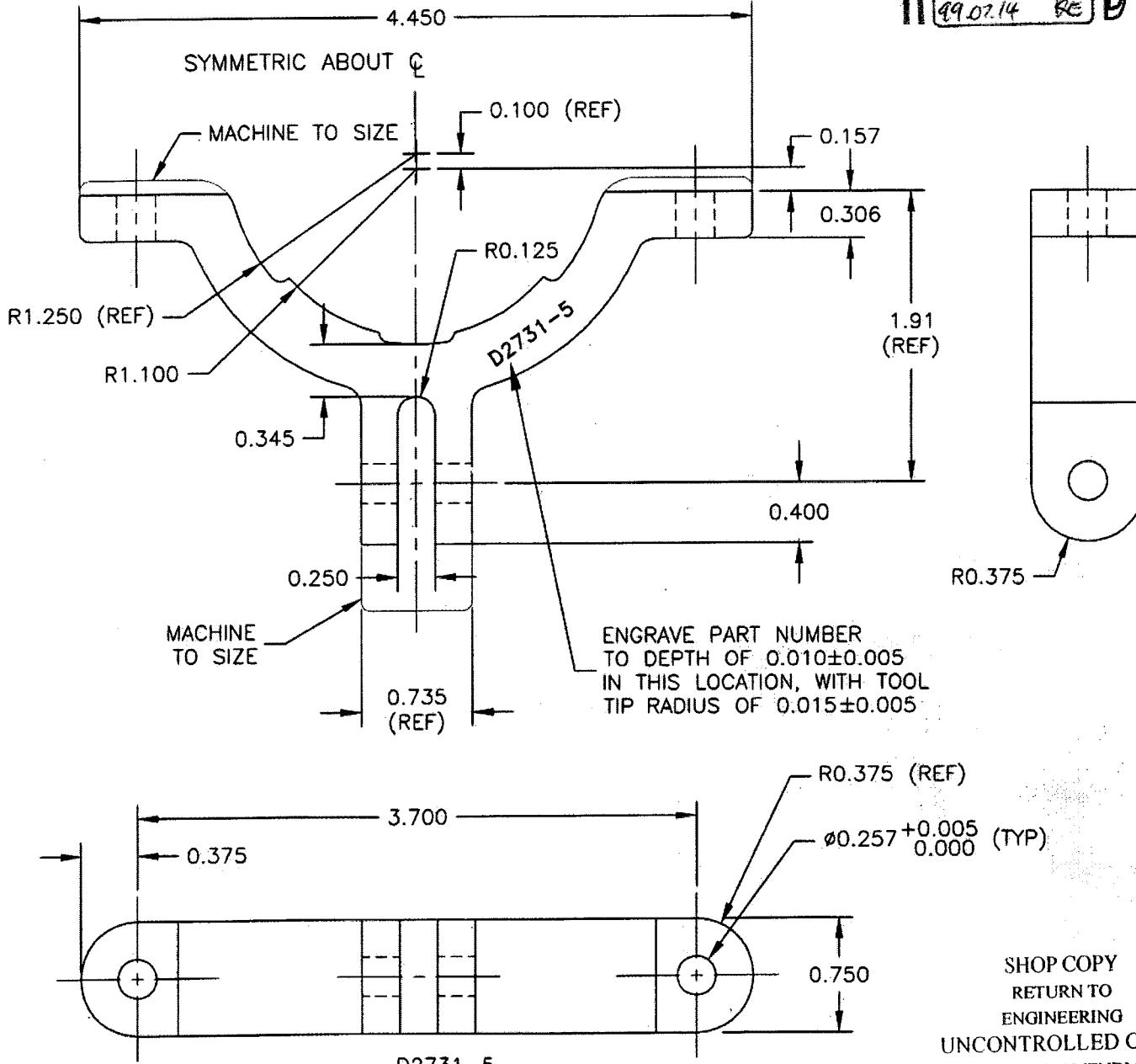
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA		
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D2731	REV. B	SHEET 3 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1	

RELEASED
99.07.14 RE



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
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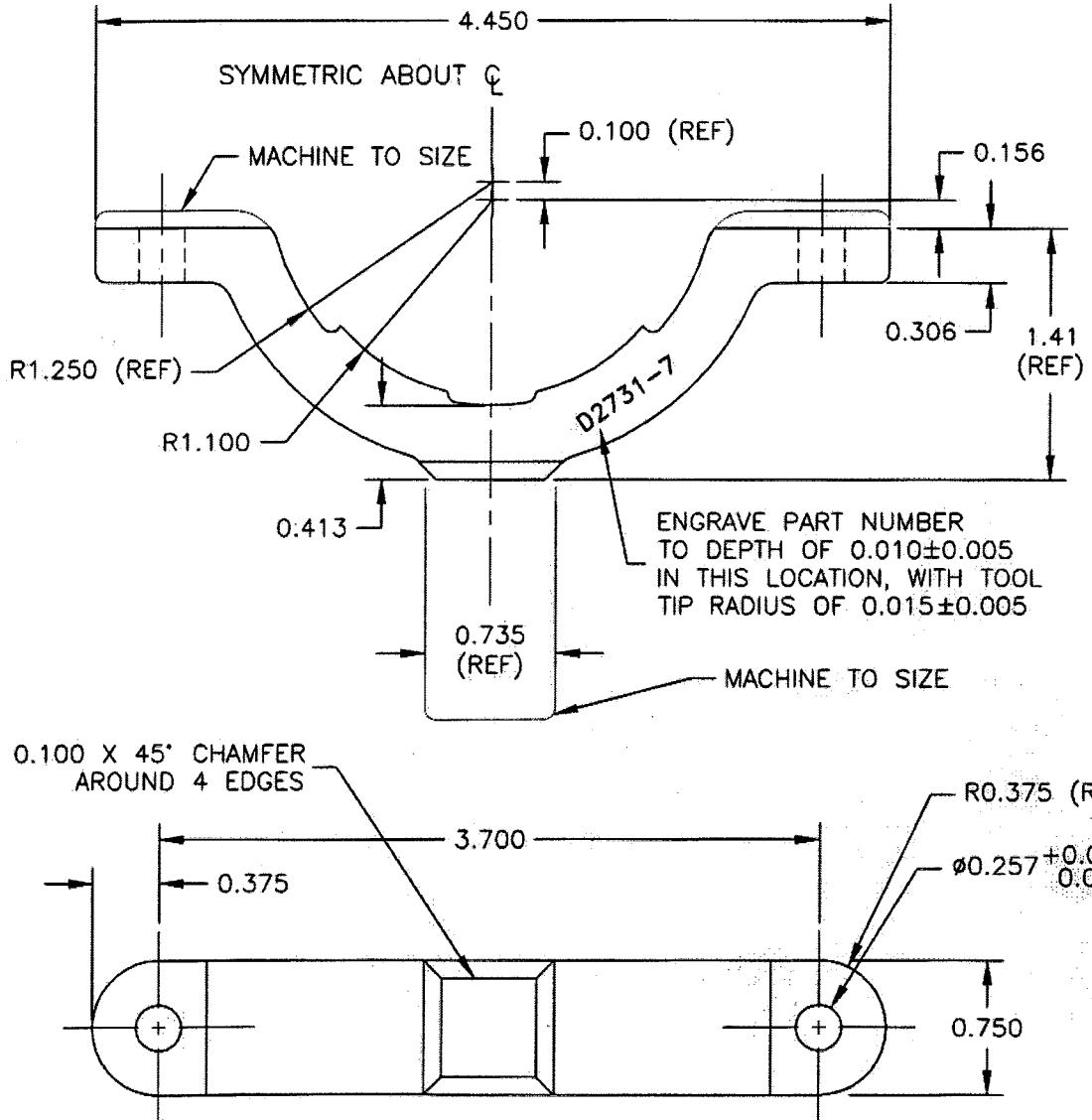
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DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>J</i>	DRAWING NO. D2731
DATE 99.07.06	TITLE MOUNTING LUG	REV. B SHEET 4 OF 4 SCALE 1:1

RELEASED
99.07.14 KE

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D2731-3	Mounting Lug	6434

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

[Signature]
METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, June 18, 2008